












Date: Tuesday, 11/22/2005 10:05:22 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 24889		
Estimate Number	: 10858		
P.O. Number	: N/A	Part Number	: D34075
This Issue	: 11/22/2005 S.O. No. : N/A	Drawing Number	: D3407 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/15/2005 Qty: 12 Um: Each
Checked & Approved By	: <u>See comment below</u>		
Comment	: Est Rev: <u>New issue 05/11/22 JLM</u>		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M174R3000	Inventory	
			
Comment: Qty.: 0.0306 f(s)/Unit Total : 0.3667 f(s) Material: 17-4ph SS Round Bar Ø3.000(M17-4-R3.000) Identify for D3407-5 Batch: <u>M18742</u> <u>ml 05/12/11</u> <u>12</u>			
2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE	
			
Comment: MORI SEIKI CNC LATHE LARGE  1-Turn as per Folio FA598 Rev: <u>A</u> & Dwg D3407 Rev: <u>C</u>  2-Deburr <u>ml 05/12/11</u> <u>12</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 05/12/11</u> <u>12</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>ED 05/12/11</u> <u>12</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>423</u> <u>CL 05/12/12</u> <u>(12)</u>			

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Drawing Name: RING

Job Number: 24889

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

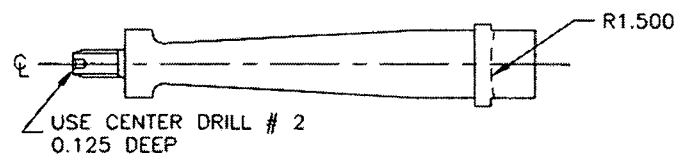
Inspection Level 21

548 05/12/13 (12)

05/12/13 (12)

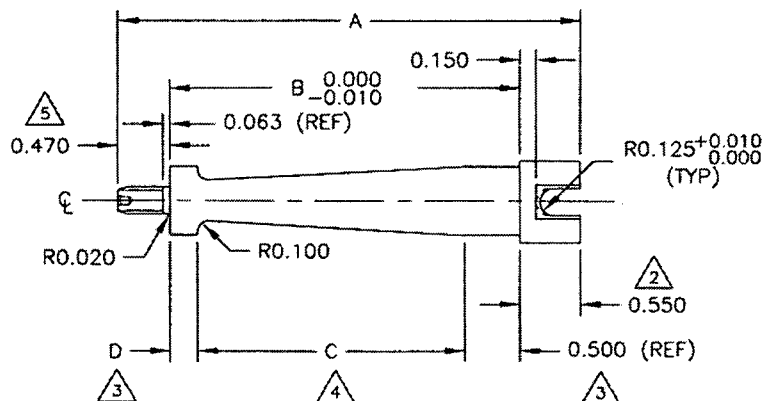
Job Completion





**RELEASED**

05 09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

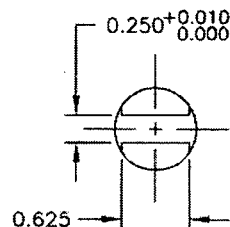
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

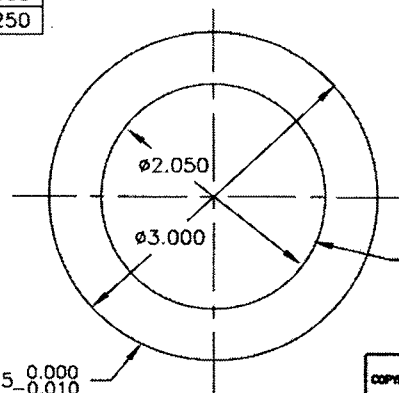
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

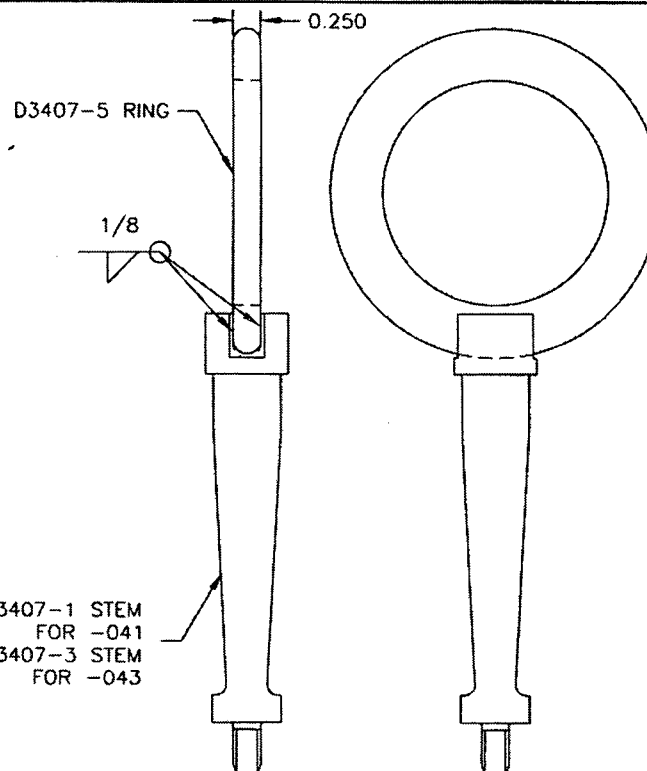
- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043



### D3407-5 RING



### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	CP
CHECKED	CP	CP
APPROVED	CP	CP
DRAWING NO.	D3407	REV. 2
DATE	05.09.09	TOW RING
SHEET	1 OF 1	SCALE
		1:1

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**DART AEROSPACE USA, INC.**  
PORT HANCOCK, MD

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 18, 2005  
09:21 am

Work Order No	:	0024889	Department Code:	
Project Name	:	D3407-5	Burden Flags	: NNNNNNNN
Project For	:	WK549	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3407-5	Invoice Number	:
Description	:	Ring	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	12	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

